

Date: Friday, 11/18/2005 5:38:19 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOW CAP
Job Number : 24887	
Estimate Number : 10483	
P.O. Number : <i>N/A</i>	Part Number : D3401041
This Issue : 11/18/2005 S.O. No. : <i>N/A</i>	Drawing Number : D3401 REV B
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 24121	Material : <i>N/A</i>
Written By : <i>See comment below</i>	Due Date : 12/15/2005
Checked & Approved By : <i>See comment below</i>	Qty: <i>4</i> Um: Each
Comment : Est. A 05.09.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R3500	Inventory
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Comment: Qty.: 0.3675 f(s)/Unit Total: 1.8375 f(s)

Inventory

Material: 6061-T6 Round Bar (QQ-A-225/8 or QQ-A-200/8)

(M6061T6R3.500)

Batch: *M18745**21.250"**J.G 05/12/06 (5)*

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA532 & Dwg D3401

Folio Rev: *A1*Dwg Rev: *B*

Deburr

*BG 05.12.09**5*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*BG 05.12.09**5*

4.0	BAND SAW	BAND SAW
-----	----------	----------

Comment: BAND SAW *HAAS*

Machine as per Folio FA532 and Dwg D3401

Dwg Rev: *B*Folio Rev: *B*

Identify as D3401-1

Deburr & Buff rad as per Dwg D3401

*En 06/01/06**4**pho*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*BG 06.01.06**4*

WORK ORDER CHANGES									
W/O	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:38:19 PM
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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and c'sink using DT8782 as per Dwg D3401

SB 06/01/09

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2060109

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 06 01 09

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 06 01 10

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LA 06-01-12

11.0

NAS1330C3KB116

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Qty Part number Description Batch

4 NAS1330C3KB116 Insert

M 14014

Assemble as per Dwg D3401

Identify as D3401-041

M 06 01 09

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

f 06/01/12

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:38:19 PM
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Drawing Name: TOW CAP

Job Number: 24887

Part Number: D3401041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/12 (4)

12/26/12

Job Completion



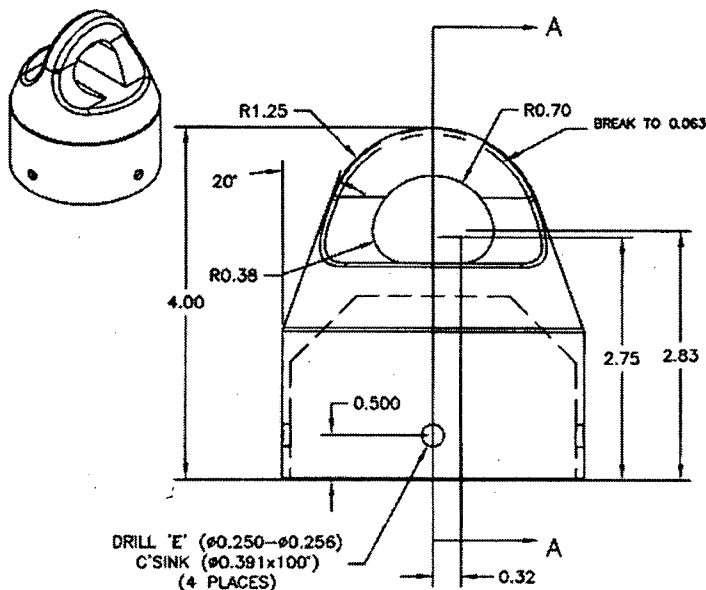
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/01/06
 QA: N/C Closed: _____ Date: _____

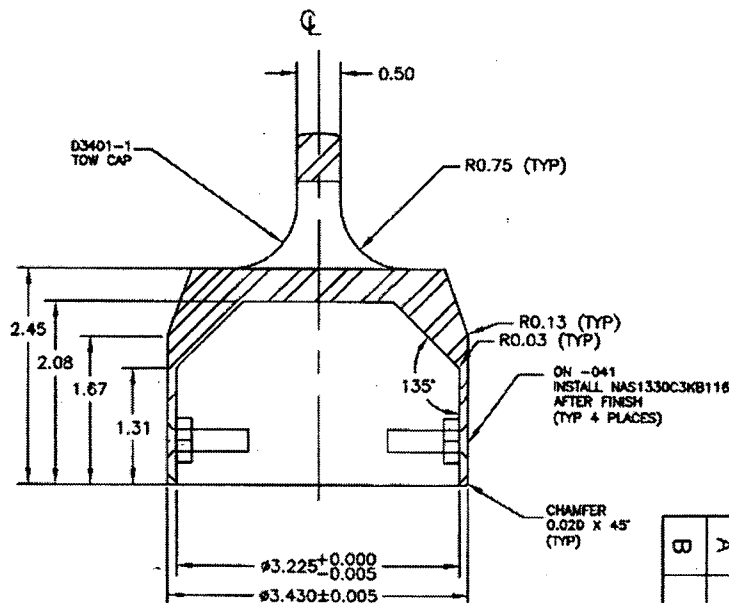
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/06	# 4	one part scrap. 0.50" dim is 0.452". A tool pulled out of holder	<u>DP</u> 06/01/06	Scrap and destroy	<u>En</u> 06/01/06	<u>DP</u> 06-01-06	<u>DP</u> 06/01/06	<u>DP</u> 06-01-06

NOTE: Date & initial all entries

DART



D3401-1 TOW CAP



SECTION A-A

D3401-1/-041 TOW CAP

D3401-1 TOW CAP

- 1) MATERIAL: MAKE FROM ALUMINUM 6061-T6 $\phi 3.500$ ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3401-041 TOW CAP

- 1) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT

RELEASED
05-08-07

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
PH	PH	PORT HADLOCK, VA
CHECKED	APPROVED	DRAWING NO. D3401
DATE 05.06.09	05.02.24	TOW CAP
A	05.06.09	NEW ISSUE
B		CHAMFER INSIDE, REMOVE RADIUS
		SCALE 1:2
		SHEET 1 OF 1
		REV. B

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	:	0024887	Department Code:	
Project Name	:	D3401-041	Burden Flags	: NNNNNNN
Project For	:	WK549	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3401-041	Invoice Number	:
Description	:	Tow Cap Assembly	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	5	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-18-05		
Est Finish Date	:	12-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24887
Description: TOW CAP		Part Number: 03401
Inspection Dwg: 03401 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	$\pm .03$	4.003	✓			
20°	$\pm 1/2^\circ$	20°	✓			
R.38	$\pm .03$	R.038	✓			
R.125	"	1.25	✓			
R.70	"	R.0.70	✓			
BREAK EDGE 0.63	$\pm .010$	0.063	✓			
2.83	$\pm .03$	2.83	✓			
2.75	"	2.75	✓			
.500	$\pm .010$					For Drilled holes
.32	$\pm .03$					For Drilled holes
.250	$\pm .006$ $-.000$					Drill DIA.
Ø.390 X 100°	$\pm .010$					Drilled holes
.50	$\pm .03$	0.514	✓			
R.75	"	0.75	✓			
Ø3.225	$\pm .005$ $-.005$	3.220	✓			Slide C.H. for plug
Ø3.430	$\pm .005$	3.430	✓			
1.31	$\pm .03$	1.31	✓			
1.67	"	1.68	✓			
2.08	"	2.08	✓			
2.45	"	2.466	✓			

Measured by: BG	Audited by: J.G	Prototype Approval:
Date: 05.12.09	Date: 06/01/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	